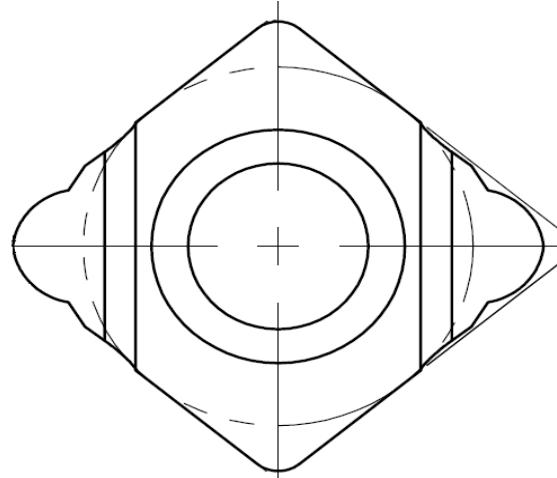


Insert CPGT0903 ID-Ø9.525 R1.78

A08-010



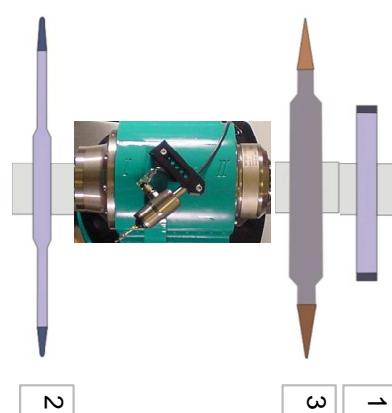
1. Cycletime for Production

Workpiece: 80° Ref ID-Ø9.525, T3.18 Material CARBIDE					
Operations	Probe prof	Chipbreaker	Pregrinding	Finishing	Load
Feed [mm/Min]	2000	40	15	20	9000
Power [kW]		3	3	2	1
Cutting speed [m/s]		20	20	22	
Used wheels					
Grinding time [s]	18	54	162	126	11
Total cycle time	6 Min 11				

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø125 D64
2	14EE1 Ø300 D76V20°
3	14EE1 Ø300 D46V20°



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 310i

Software: Quinto 5

Accessories: Loader STL6050, RPC clamping

Responsible engineer: OP, 29.8.14

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J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland
Subsidiaries in: France, Deutschland, Italia, United States, UK, China

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